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“जानने का अधिकार, जीने का अधिकार”

Mazdoor Kisan Shakti Sangathan

“The Right to Information, The Right to Live”

“पुराने को छोड़ नये के तरफ”

Jawaharlal Nehru

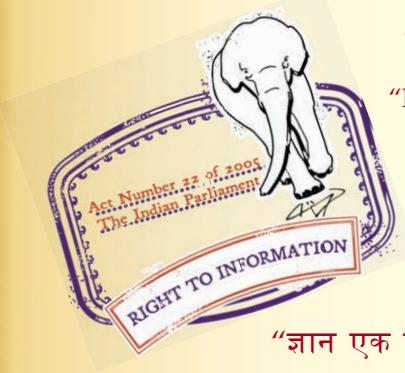
“Step Out From the Old to the New”

IS 5251 (1984): Table Clamps [PGD 2: Machine Tool Elements and Holding Devices]

“ज्ञान से एक नये भारत का निर्माण”

Satyanaaranay Gangaram Pitroda

“Invent a New India Using Knowledge”



“ज्ञान एक ऐसा खजाना है जो कभी चुराया नहीं जा सकता है”

Bhartṛhari—Nītiśatakam

“Knowledge is such a treasure which cannot be stolen”



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Indian Standard
SPECIFICATION FOR TABLE CLAMPS
(First Revision)

1. Scope — Specifies the dimensions and material for table clamps used in holding work pieces in place when they are being machined.

2. Dimensions — Shall be as given in Table 1.

3. Designation — A table clamp having $d = 18$ mm and $h = 40$ mm shall be designated as:

Table Clamp 18 x 40 IS : 5251

4. Material — Steel suitably hardened and tempered to a tensile strength of 750 to 850 N/mm².

5. Finish — The table clamps shall be free from cracks, burrs, pits and other defects. These shall also be free from sharp corners.

6. Preservation and Packing

6.1 A suitable anti-corrosive surface treatment shall be given to table clamps.

6.2 The table clamps shall be packed in accordance with best trade practice.

7. Marking

7.1 The table clamps shall be marked at an appropriate place with designation, manufacturer's name or trade-mark.

7.2 ISI Certification Marking — Details available with the Indian Standards Institution.

EXPLANATORY NOTE

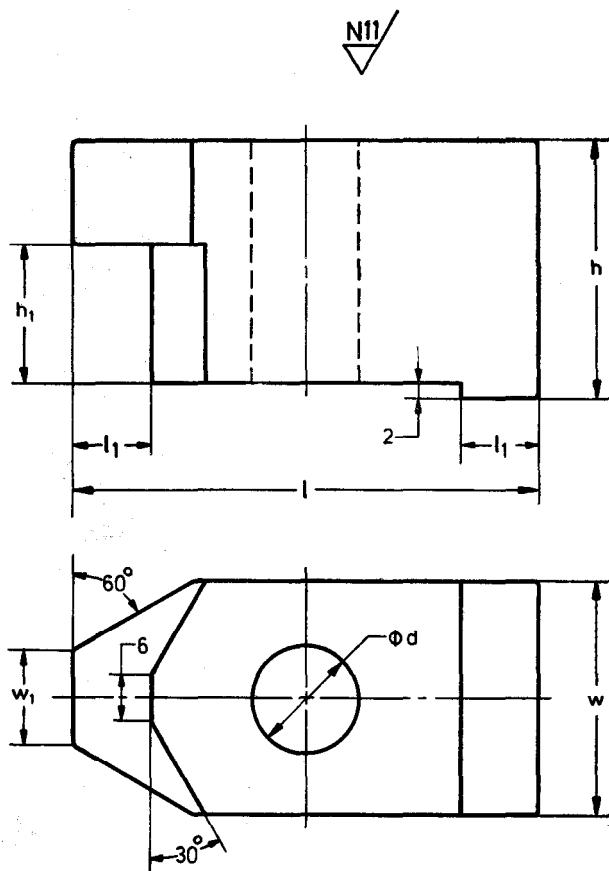
This standard was first published in 1969. The committee responsible for formulation of this standard decided to revise the same based upon experience gained over so many years and to keep it in line with other standards on clamps, which are also being revised, regarding material, roughness values, tolerance and rationalisation of sizes.

In the present revision, the figure under Table 1 has been modified to provide 'relief' to suit the present practice.

TABLE 1 DIMENSIONS FOR TABLE CLAMPS

(Clause 2)

All dimensions in millimetres.



d H13	h	h_1	l	l_1	w	w_1	Size of Screw
11	20	10	50	8	25	10	M10
11	23	13	50	8	25	10	M10
11	25	15	50	8	25	10	M10
11	30	20	50	8	25	10	M10
14	26	13	60	10	30	12	M12
14	28	15	60	10	30	12	M12
14	33	20	60	10	30	12	M12
18	35	20	75	14	40	14	M16
18	40	25	75	14	40	14	M16
22	40	20	90	18	45	18	M20
22	45	25	90	18	45	18	M20

Note — Dimensional deviations for untoleranced dimensions:
Coarse class according to IS : 2102 (Part 1)-1980 'General tolerances for dimensions and form and position: Part 1 General tolerances for linear and angular dimensions (second revision)'.